

Ship 16 JAN.

Work Order ID 153682

153682

Page 1

Thursday, November 24, 2016 9:28:07 AM

Item ID: D205-541-053 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Automatic Lid Opener
 Start Date: 11/24/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/6/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 11-24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9710	B								

100

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D205-541-053 Chg 001

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

DAS
6
9-89

DEC 12 2016

DAS
6
9-89

DEC 15 2016

NF 11-12-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 153682

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153682

Page 2

Item ID: D205-541-053

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Automatic Lid Opener

Start Date: 11/24/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D205-541-053
Location: _____

#15 3681

JMF 16-12-22

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

DAS
21
9-89

DEC 22 2016

JMF
16-12-22

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Picklist Print

Thursday, November 24, 2016 9:28:14 AM

Page 1

Work Order ID: 153682

153682

Parent Item: D205-541-053

D205-541-053

Parent Item Name: Automatic Lid Opener

Start Date: 11/24/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 16.05.24 as per dsi rev.b DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3953-3		Manufactured	No				Each	42.0000		4			
D3953-3									**				
Gas Spring Stud, Lid													

Location	Loc Qty	Loc Code
ST062	10	
149582	10	
ST064A	32	
147675	10	
148400	12	
153037	10	

DAS
6
9-89
DEC 15 2016

D3953-7		Manufactured	No				Each	22.0000		4			
D3953-7									**				
Spring Spacer													

Location	Loc Qty	Loc Code
ST062	22	
147641	10	
148382	12	

DAS
6
9-89
DEC 15 2016

D3953-9		Manufactured	No				Each	51.0000		4			
D3953-9									**				
Gas Spring Washer													

Location	Loc Qty	Loc Code
ST062	51	
145912	51	

DAS
6
9-89
DEC 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Thursday, November 24, 2016 9:28:14 AM

Page 2

Work Order ID: 153682

153682

Parent Item: D205-541-053

D205-541-053

Parent Item Name: Automatic Lid Opener

Start Date: 11/24/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

D3953-17 Manufactured No

Each 52.0000 6

D3953-17

Gas Spring Spacer

DEC / 5 2016

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST062	52	
145690	2	
147373	10	
149542	16	
152231	24	

2
3

mf

DAS
6
9-89

D3953-19 Manufactured No

Each 23.0000 2

D3953-19

Gas Spring Bracket

DEC / 5 2016

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST062	9	
145653	9	
ST064A	14	
147350	14	

2

mf

D3953-21 Manufactured No

Each 30.0000 2

D3953-21

Gas Spring Bracket

DEC / 5 2016

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST063	30	
145806	7	
147443	14	
152996	9	

2

mf

D3969-3 Manufactured No

Each 8.0000 2

D3969-3

Spring (Basket Lid)

DEC / 5 2016

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST365	8	
148841	8	

2

mf

Thursday, November 24, 2016 9:28:14 AM

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Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Thursday, November 24, 2016 9:28:14 AM

Work Order ID: 153682

153682

Parent Item: D205-541-053

D205-541-053

Parent Item Name: Automatic Lid Opener

Start Date: 11/24/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

AN3-14A Purchased No

Each 94.0000 4

AN3-14A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
over003	80	
m134852	0	
m135600	30	
m135966	50	
ST349	14	
m135056	14	

DEC 15 2016

DA 6

9-8

mf

136263

AN3-20A Purchased No

Each 31.0000 4

AN3-20A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST348	31	
117441	12	
m135056	19	

DEC 15 2016

D/ PAS 6 9-8

mf

4

AN310-4 Purchased No

Each 88.0000 4

AN310-4

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	25	
M127815	25	
OVER007	35	
M135999	35	
ST331	28	
M134955	1	
M135704	27	

DEC 15 2016

D PAS 6 9-8

mf

4

Thursday, November 24, 2016 9:28:15 AM

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Parent Item Name: Automatic Lid Opener

Start Date: 11/24/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

2,250.000

8

MS21042L3

Nut

DEC 15 2016

DAS
6
7-89LocationLoc QtyLoc Code

CCK007

600

M136192

600

FP001

100

m135945

100

GA

196

m134360

108

m135135

88

OVER007

600

M136044

600

ST303

754

m135767

254

m135945

500

Each

142.0000

4

DEC 15 2016

AS
3
39LocationLoc QtyLoc Code

ST289

142

113815

142

Each

2,114.000

16

DEC 15 2016

AS
6
89

MS24665-231

Purchased

No

MS24665-231

cotter pin

NAS1149F0332P

Purchased

No

NAS1149F0332P

Washer

LocationLoc QtyLoc Code

GA

343

m133709

343

ST262

1771

m135948

1771

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Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement ☐		☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER :							
Misidentified ☐	☐	Past Due ☐									

Picklist Print

Page 5

Thursday, November 24, 2016 9:28:15 AM

Work Order ID: 153682

153682

Parent Item: D205-541-053

D205-541-053

Parent Item Name: Automatic Lid Opener

Start Date: 11/24/2016

Required Date: 12/6/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0463P

Purchased

No

Each

594.0000

4

NAS1149F0463P

Washer

DEL 12/10/16

DAS
6
9-89

Location

Loc Qty

Loc Code

ST262

594

m127832

594

4

ms

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date: _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF. TCCA STC SH96-120,
FAA STC SR00696NY
EASA STC EASA.IM.R.S.01242

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. **153682**

1.0 PURPOSE:

The purpose of this DSI is to provide operators of Bell 205/210/212/214/412 Rotorcraft equipped with Dart D205-541-043/-044/-045/-046 Heli-Utility-Baskets with an Upgrade Kit to replace the existing Lid Prop Arm Assembly with an Automatic Lid Opening Gas Spring Kit. The D205-541-051 Automatic Lid Opener Kit includes parts and hardware to install a gas spring on both ends of the D205-541-043/-044 basket. The D205-541-053 Automatic Lid Opener Kit includes parts and hardware to install a gas spring on both ends of the D205-541-045/-046 basket.

2.0 PARTS LIST:

ITEM No.	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
	X		D205-541-051	AUTOMATIC LID OPENER KIT
		X	D205-541-053	AUTOMATIC LID OPENER KIT
1	4	4	D3953-3	GAS SPRING STUD
2	4	4	D3953-7	GAS SPRING SPACER
3	4	4	D3953-9	GAS SPRING WASHER
4	6	6	D3953-17	GAS SPRING SPACER
5	2	2	D3953-19	GAS SPRING BRACKET
6	2	2	D3953-21	GAS SPRING BRACKET
7		2	D3969-3	GAS SPRING
8	2		D3969-9	GAS SPRING
9	4	4	AN3-14A	BOLT
10	4	4	AN3-20A	BOLT
11	4	4	AN310-4	CASTELLATED NUT
12	8	8	MS21042L3	NUT
13	4	4	MS24665-231	COTTER PIN
14	16	16	NAS1149F0332P	WASHER
15	4	4	NAS1149F0463P	WASHER

***Note:**

For customers wishing to order new baskets with the Lid Opener pre-installed, use the following numbers:

D205-541-043 BASKET with AUTOMATIC LID OPENER installed = D205-541-043A
D205-541-044 BASKET with AUTOMATIC LID OPENER installed = D205-541-044A
D205-541-045 BASKET with AUTOMATIC LID OPENER installed = D205-541-045A
D205-541-046 BASKET with AUTOMATIC LID OPENER installed = D205-541-046A

3.0 PROCEDURE:

For D205-541-043/-044/-045/-046 Heli-Utility Baskets, replace the existing Prop Arm Assembly with gas springs on both ends of the basket. (NOTE: Once this modification is complete, it will not be possible to re-install the D2332-041 Prop Arm Assembly)

3.1 Remove the D2332-041 Prop Arm Assembly.

3.2 Grind flush and deburr the D2327-3 Spacer Bushing from the end of the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
	D. SHEPHERD (DE # 02)
DATE:	16.05.12
CERT. NO.:	SH96-120
ISSUE NO.:	3

B	FLIP GAS SPRING ORIENTATION, ADD D3969-9 ADD-053 KIT, NAS1149F0332P WASHER WAS 0363P	CP	16.05.12
A	NEW ISSUE	DB	15.02.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9710	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AUTOMATIC LID OPENER INSTL	NTS
DATE	16.05.12	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- 3.3 Locate the QTY 2 D3953-17 Gas Spring Spacer on the basket lid per Figure 1 (-043/-044) or Figure 2 (-045/-046). Trim steel mesh locally as required. Transfer mark and drill 2X Ø0.194 holes thru basket lid. Touch up paint per ICA-D205-541, Section 5.1.5. (Later model D2512 Basket Lids may be pre-drilled for gas spring brackets)
- 3.4 Install QTY 2 D3953-17 Gas Spring Spacer and D3953-19 Gas Spring Bracket to the basket lid using 2X AN3-20A bolts, NAS1149F0332P Washers and MS21042L3 Nuts as shown in Figure 3.
- 3.5 Locate the D3953-17 Gas Spring Spacer on the basket base as shown in Figure 1 (-043/-044) or Figure 2 (-045/-046). Trim steel mesh locally as required. Transfer mark and drill 2X Ø0.194 holes thru the basket base. Touch up paint per ICA-D205-541, Section 5.1.5.
- 3.6 Install the D3953-17 Gas Spring Spacer and D3953-21 Gas Spring Bracket to the basket base using 2X AN3-14A bolts, NAS1149F0332P Washers and MS21042L3 Nuts, as shown in Figure 3.
- 3.7 Insert D3953-3 Gas Spring Studs through the D3953-19 and D3953-21 Gas Spring Brackets from the inside of the basket. (May be performed prior to 3.6 if necessary because of basket mesh).
- 3.8 Install a D3953-7 Gas Spring Spacer on to each stud followed by the D3969-9 Gas Spring for D205-541-051 Kits or the D3969-3 Gas Spring for D205-541-053 Kits, D3953-9 Gas Spring Washer, NAS1149F0463P Washer and AN310-4 Castellated Nut. To secure the nut, install a MS24665-231 Cotter Pin into the D3953-3 Gas Spring Stud per MS33540 or AC43.13 Chapter 7-127.
NOTE: - With the Lid in the closed position, the D3969 Gas Spring should NOT be fully compressed.
- Open the lid to accommodate the installation of the fully extended gas spring.
- 3.9 Repeat the installation on the opposite end of the basket.
- 3.10 Test the installation. If installed properly, the Gas Springs should assist in both opening and closing the basket lid.

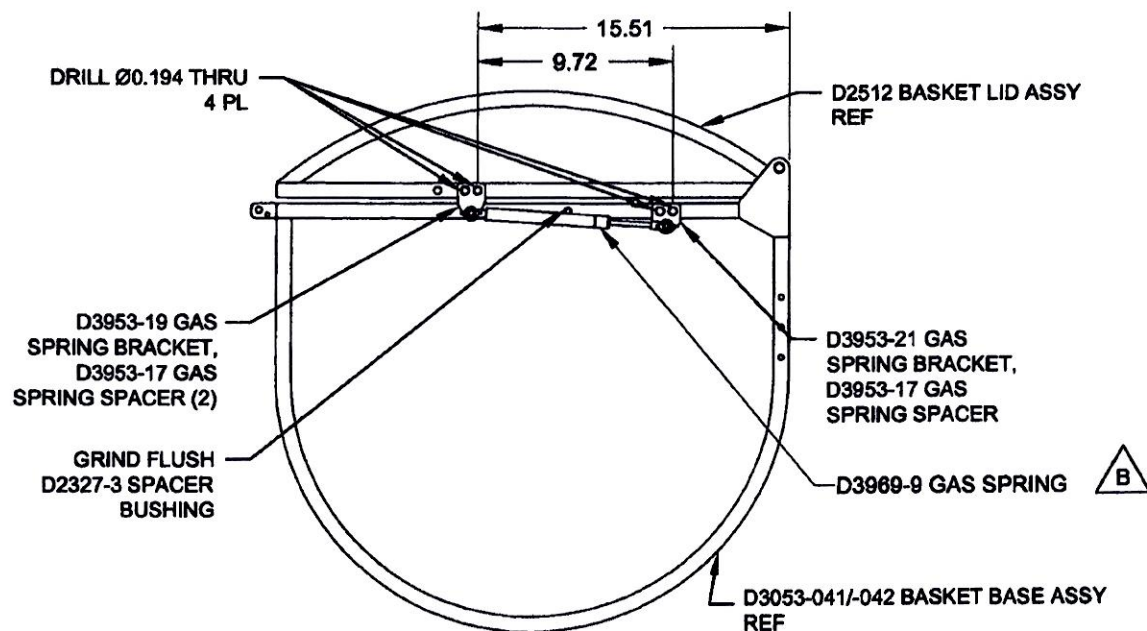


FIGURE 1: D205-541-051 AUTOMATIC LID OPENER INSTALLATION
(ON D205-541-043/-044 HELI-UTILITY BASKET, BOTH ENDS)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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D. SHEPHERD (DE # 02)
DATE: 16.05.12
CERT. NO.: SH96-120
ISSUE NO.: 3

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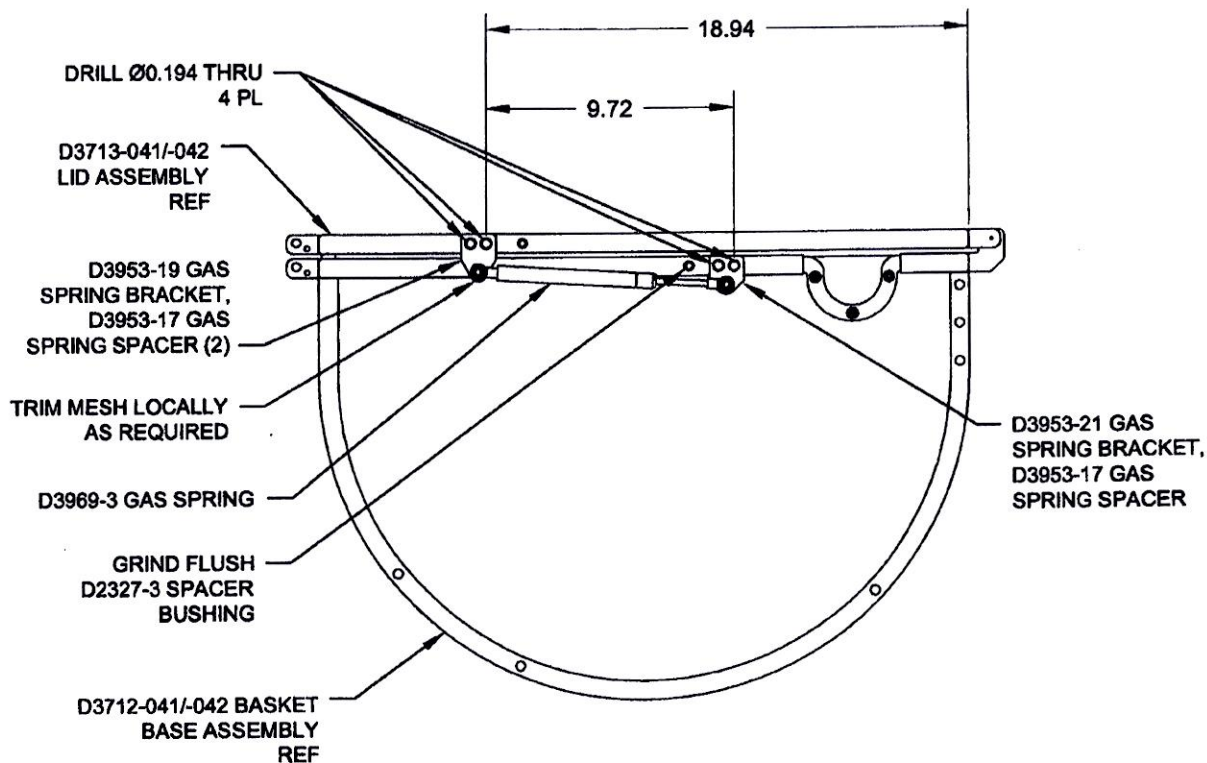


FIGURE 2: D205-541-053 AUTOMATIC LID OPENER INSTALLATION
 (ON D205-541-045/-046 HELI-UTILITY-BASKET, BOTH ENDS)
 (MESH NOT SHOWN FOR CLARITY)

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 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

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 D. SHEPHERD (DE # 02)

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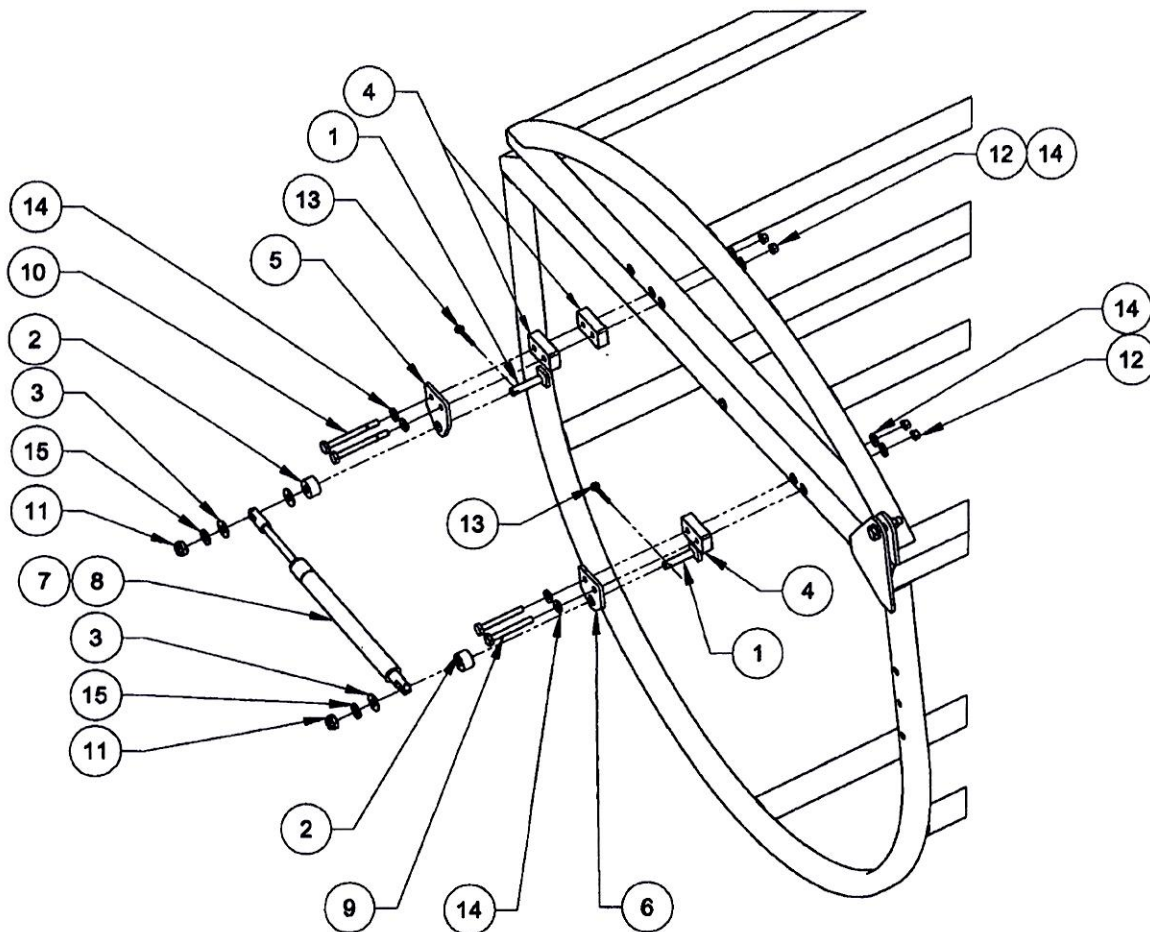


FIGURE 3: D205-541-051/-053 GAS SPRING KIT INSTALLATION
 (ON D205-541-043/-044: LH SIDE, AFT END SHOWN/RH SIDE AND FWD END SIMILAR)
 (MESH NOT SHOWN FOR CLARITY)

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-051/-053	0.69 lb	- 63.13 in	- 43.6 in-lb	132.25 in	91.3 in-lb
Automatic Lid Opener Kit	0.31 kg	- 1.60 m	- 0.5 m-kg	3.36 m	1.0 m-kg

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